

5/20

| | | | |
|---|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 23135 |
| Description: 206 A/B High Gear Web | | Part Number: | D2654-3 |
| 05.01.13 E1 05.01.13 | | | |
| Drawing: D2654 Rev. 2 DEO 9136 | | Qty: | 2 |

| Step | Location | Procedure | By | Date | Qty |
|------|------------|---|--------|----------|-----|
| 1 | EXPEDITING | Issue Work Order | DP | 05.04.29 | 2 |
| 2 | METAL | Pick: Qty Part Number Description Batch 1 D2600-5 Web B12433 | DP | 05/5/10 | 2 |
| 3 | METAL | Cut D2600-5 to length as per Dwg D2654 | DP | 05-8-22 | 2 |
| 4 | METAL | Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 | P.M.C. | 05-8-29 | 2 |
| 5 | METAL | Using the uni-bit, open holes to finish size as per Dwg D2654 | P.M.C. | 05-8-29 | 2 |
| 6 | METAL | Deburr holes and ends | P.M.C. | 05-8-29 | 2 |
| 7 | METAL | Acid Etch and Alodine as per QSI 005 4.1 | P.M.C. | 05-8-30 | 2 |
| 8 | QC | Inspect Level 5 | J | 05-08-30 | 2 |
| 9 | METAL | Identify and stock | P.M.C. | 05-9-7 | 2 |
| 10 | EXPEDITING | Close Work Order Inspect level 21 Cost/part: 33.61 545 05/09/08 (2) 47 05/09/08 | | | 2 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-------------------------------|------------|----------|
| A | 97.07.30 | New Issue | JB | |
| B | 97.08.28 | Change part No. Step 1 & 2 | KS | |
| C | 98.09.14 | Re-format, drawing rev. | CS | |
| D | 99.02.04 | Fixed typo, Changed procedure | DM | 02-05-27 |

RELEASED

02/05/11

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LD* Date: 25/09/08

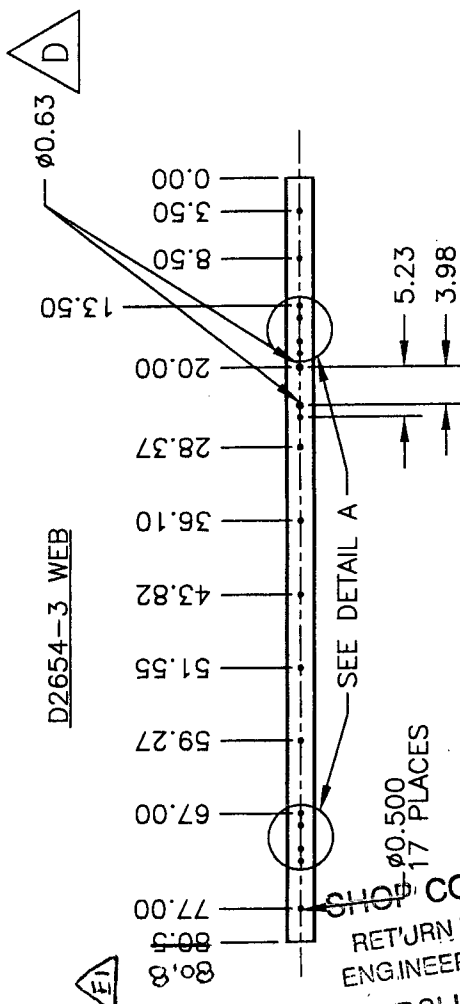
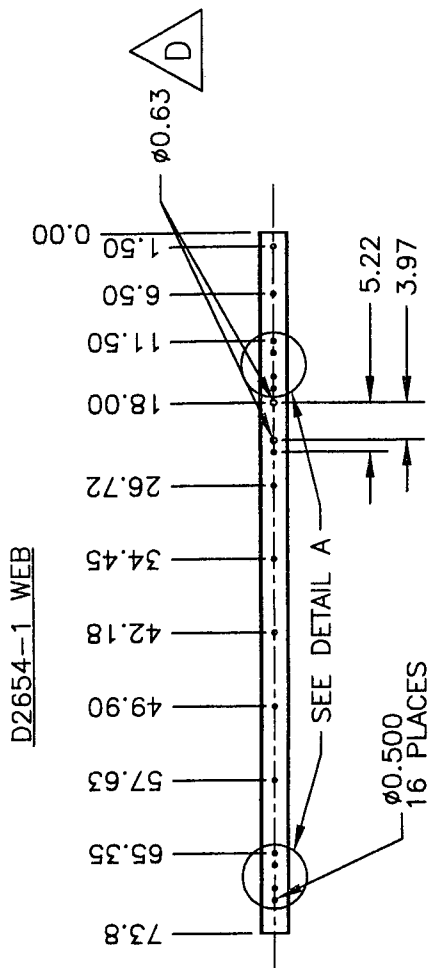
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D2654 | REV. E SHEET 1 OF 2 |
| DATE 04.05.26 | TITLE WEB | | SCALE 1:20 |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.26 | ALTER HOLE PATRN., 0.500 WAS 0.438 | |
| C | 97.10.29 | CHANGED HOLE PATTERN | |
| D | 98.01.15 | GHW HOLES CHANGED TO $\phi 0.63$ | |
| E | 04.05.26 | CHANGE LENGTHS, REFORMAT | |
| E1 | <i>CP</i> 04.08.04 | PER TOOLING; 80.8 WAS 80.5 | |

RELEASED
04.06.22



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WITHOUT NOTICE
WORK ORDER
NO. 23135

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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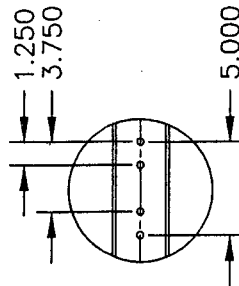
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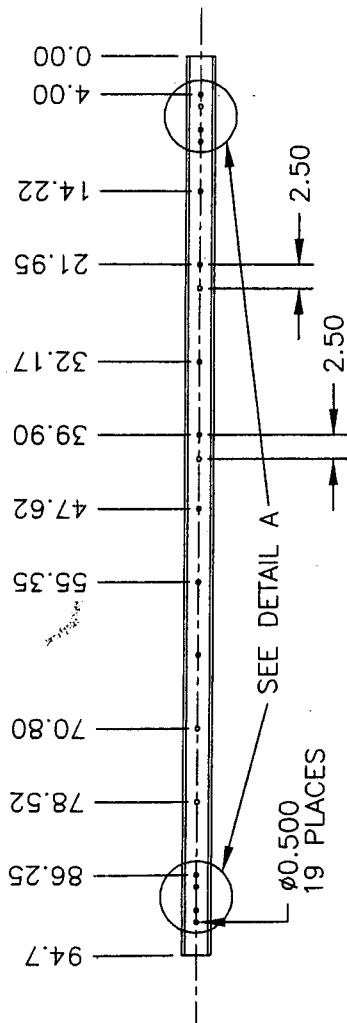
| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2654 | REV. E SHEET 2 OF 2 |
| DATE 04.05.26 | | TITLE WEB | SCALE 1:20 |

RELEASED
04.06.2004

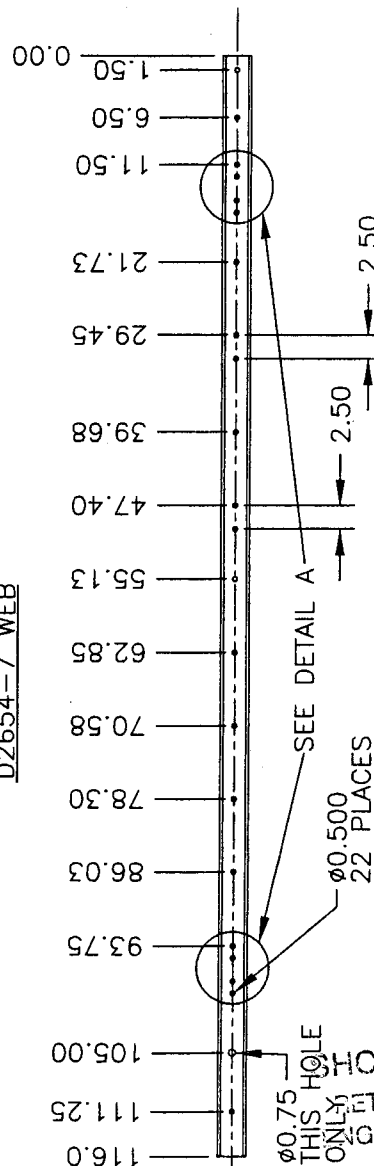
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
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T
ENDMENT

WORK ORDER
NO. 23135

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| | | | |
|------------------|---|---|------------------------|
| DESIGN DS | DRAWN BY DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED DM | APPROVED KE | DRAWING NO. DEO 9136 | REV. A SHEET 1 OF 1 |
| DATE 99.02.26 | TITLE 206 SKIDTUBE WEB LENGTH CHANGE | | SCALE NTS |
| A | 99.02.26 | NEW ISSUE | |

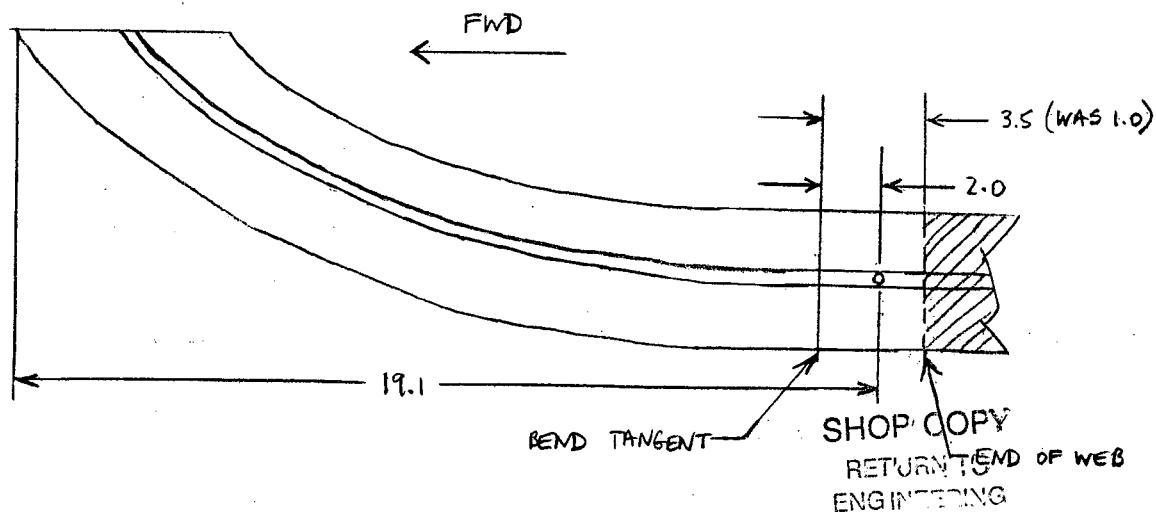
DART ENGINEERING ORDER

TO AMEND DWGS: D2650 REV. C
D2654 REV. D

TO FACILITATE BENDING D206-642 SKIDTUBES IN-HOUSE, ALL WEBS CALLED UP ON DWG D2654 SHOULD BE SHORTENED BY 2.50" AT THE FWD END. THIS WILL ELIMINATE THE NEED TO DRILL THE FWD HOLE ON ALL WEBS SHOWN ON DWG D2654. THE REVISED LENGTHS ARE AS FOLLOWS:

| <u>PART NO.</u> | <u>LENGTH WAS</u> | <u>LENGTH NOW</u> |
|-----------------|-------------------|-------------------|
| D2654-1 | 76.35 | 73.85 |
| D2654-3 | 83.35 | 80.85 |
| D2654-5 | 92.25 | 94.75 |
| D2654-7 | 118.50 | 116.00 |

THE BENDING DETAIL ON PAGE 7 OF DWG. D2650 WILL NOW BE AS FOLLOWS:



IT IS ACCEPTABLE TO ENGINEERING TO HAVE A MAXIMUM REDUCTION OF 0.150" FWD OF THE WEB IN THE BENT PORTION OF THE TUBE. SUBJECT TO APPROVAL WITHOUT NOTICE.

RELEASED
99.03.02 DS

WORK ORDER

NO. 23135

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 29, 2005
11:31 am

| | | | |
|-------------------|--------------------|------------------------------|----------------|
| Work Order No | : 0023135 | Department Code: | |
| Project Name | : D2654-3 | Burden Flags | : NNNNNNNN |
| Project For | : WK520 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : D2654-3 | Invoice Number | : |
| Description | : 206 I-Beam (Web) | Invoice Amount | : 0.00 |
| Manufactured | : Yes | | |
| Amount Req'd | : 2 | Order Entry No | : |
| Amount Done | : 0 | OE Value | : 0.00 |
| Start Date | : 04-29-05 | | |
| Est Finish Date | : 05-15-05 | Est Mark Up | : 0.000% |
| Act Finish Date | : | Actual Mark Up | : 0.000% |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | 0.00 | 0.00 | 0.00 | | |
| Production Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | 0.00 | 0.00 | 0.00 | | |
| CNC | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | 0.00 | 0.00 | 0.00 | | |
| Misc. | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | 0.00 | 0.00 | 0.00 | | |
| Total Cost | 0.00 | 0.00 | 0.00 | | |
| Mark up | 0.000 | 0.000 | | | |
| Selling Cost | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00 | 0.00 |
| Profits/(Loss) | 0.00 | 0.00 |